



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3210-1
Job Sheet 185960



Part No: D3210-1

Job Qty: 4 ea

Part Name: Doubler For Interior Window -015 & -025



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-17 JLM IPP Rev:B Now On Waterjet 06-10-24 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		11/28/18	0.00	0.96	Waterjet - Flow		SR 18/11/15
120	QC	4 pcs		11/28/18	0.00	0.00	QC8		38
130	Small Fab	4 pcs		11/28/18	0.00	0.00	Small Fab-3		9-89
140	QC	4 pcs		11/28/18	0.00	0.00	QC5		38
150	HandFinish	4 pcs		11/28/18	0.00	0.28	HandFinish1		DR 18/11/20
155	QC	4 pcs		11/28/18	0.00	0.00	QC7-2		8-FB 18-11-20
160	Powdercoat	4 pcs		11/28/18	0.00	0.13	Powdercoat4		DAS
170	QC	4 pcs		11/28/18	0.00	0.00	QC3		38
180	Packaging	4 pcs		11/28/18	0.00	0.00	Packaging3-1		NOV 23 2018
190	QC21-SA	4 Ea		11/28/18	0.00	0.00	QC21		21 NOV 26 2018

Part Op 100 - 1-Cut as per Dwg D3210

Descriptions: 130 - Deburr

M38837.160 - START TIME: 11:00 TEMP: 320° FINISH: 11:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	6.8000 sf (1.7 ea)	100-Waterjet - Flow - 1	5101799

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.080	7	78	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.141inches + 0.005 - 0.000	0.146 0.141	0.143	
2	Doubler	0.128inches + 0.005 - 0.000	0.133 0.128	0.130	
3	Doubler	3.857inches ± 0.010	3.867 3.847	3.860	
4	Doubler	17.750inches ± 0.010	17.760 17.740	17.750	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐					
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																										
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																										
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																										
Large Fab ☐	Composite ☐	Supplier ☐																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																						
Dart Aerospace Ltd. 1270 Aberdeen Street Newmarket, ON L6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S128411 Part: D3210-1 Job No: 185960 Serial No/Batch: S128411 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 11/15/18				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																					
Environ: _____ Doc _____ Equip/T _____ Handli _____ Material _____ Internal Transport _____ Tribal Knowledge _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____		Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		EGORY <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Power Loss/Surge ☐</td> <td style="width:15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>		Power Loss/Surge ☐	Positioned Wrong ☐	Folio/Program ☐	Outside Dimensions ☐	Grain ☐	Over/Under tolerance ☐	Weld ☐	Part Incorrect ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Out of Sequence ☐	Part Moved ☐	Off-set ☐	Drawing ☐	Mislabeled ☐	Finish ☐	Fit/Function ☐	Misread ☐	Misaligned/off center ☐	Turning Sequence ☐
Power Loss/Surge ☐	Positioned Wrong ☐																												
Folio/Program ☐	Outside Dimensions ☐																												
Grain ☐	Over/Under tolerance ☐																												
Weld ☐	Part Incorrect ☐																												
Wrong Stock Pulled ☐	Part Lost/Missing ☐																												
Out of Sequence ☐	Part Moved ☐																												
Off-set ☐	Drawing ☐																												
Mislabeled ☐	Finish ☐																												
Fit/Function ☐	Misread ☐																												
Misaligned/off center ☐	Turning Sequence ☐																												
OTHER : _____																													

5	Doubler	20.150inches $\pm$ 0.030	20.180 20.120	20,150
6	Doubler	8.500inches $\pm$ 0.010	8.510 8.490	8,505
7	Doubler	1.095inches $\pm$ 0.010	1.105 1.085	1,098
8	Doubler	0.650inches $\pm$ 0.010	0.660 0.640	0,653
9	Doubler	0.350inches $\pm$ 0.010	0.360 0.340	0,352

Plex 11/7/18 1:25 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								